

Date: Thursday, 5/4/2006 11:12:41 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING BRACKET	
Job Number	: 26941				
Estimate Number	: 11797				
P.O. Number	: N/A		Part Number	: D2524	
This Issue	: 5/4/2006 S.O. No. : N/A		Drawing Number	: D2524 REV A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 5/20/2006	
Checked & Approved By			Qty:	12 Um: Each	
Comment	: Est. C 00.06.26 Removed P/O for powder coat EC				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M6061T6B0250X02500	6061-T6 Bar .25" x 2.5"			
Comment: Qty.: 0.7657 f(s)/Unit Total : 9.1879 f(s) 6061-T6 Bar .25" x 2.5" Material: 6061-T6 Bar - 0.25" thick Batch: M15427 SD 06.05.17 (13)					
2.0	BAND SAW	BAND SAW			
Comment: BAND SAW 250" <i>SD</i> Cut blanks: 225" x 8.75" SD 06.05.17 (13)					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2524 Tumble Deburr any rough edges after tumbling SD 06.05.17 (13)					
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SD 06.05.17 (13)					
5.0	QC5	INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP JG 06/05/17 (13)					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 2/25/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MOUNTING BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING

6.1



PRO

13

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/05/23

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



13

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM 06-05-23

8.0 PACKAGING 1

PACKAGING RESOURCE #1



13

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST47

10/05/24 (13)

9.0 DC

DOCUMENT CONTROL



13

Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/05/25 (13)

Job Completion



10/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-17	6.0	Acid: Alodine as per QSI 005 4.1. SAD 06-05-17 (13)	a.m	06-05-18 (13)			
		Add to estimate, permanent change.					06-05-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26941
Description: Side Plate	Part Number:	D2524
Inspection Dwg: D2524 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SD	Audited by:	J.F	Prototype Approval:	N/A
Date:	06/05/17	Date:	06/05/17	Date:	N/A

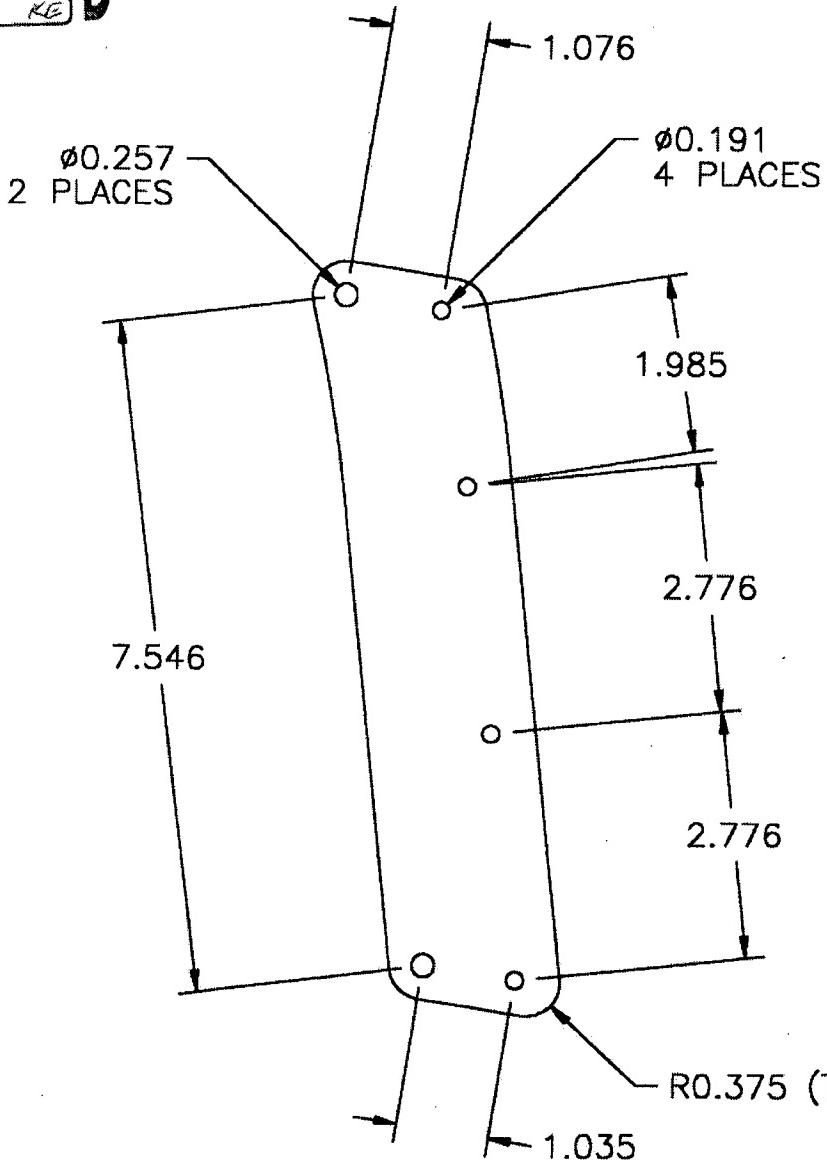
Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	KJ/JLM	SJL



3M COPY
ISSUE

DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2524	REV. A SHEET 1 OF 1
DATE 95.12.20		TITLE SIDE PLATE	SCALE 1:2
A	95.12.20	NEW ISSUE	

RELEASED
97/01/15 KE
ECN001



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: 6061-T6 QQ-A-200/8 0.25 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 *26941*
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

